

Work Order ID 76757

November-21-11 10:29:14 AM

76757

Page 1

Item ID: D2654-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 21/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 02/01/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: U.L.J. Date: 11/11/21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	F								

100 Skidtubes 0.00

100

Skidtubes

Skidtubes

Memo

1-Cut D2600-5 to length as per Dwg D2654
 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654
 3-Using the uni-bit, open holes to finish size as per Dwg D2654
 4-Deburr holes and ends

0.00

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC

Quality Control

Memo

0.00

120 Chemical Conversion Coat per QS1005 4.1 0.00

120

HandFinish

Hand Finishing

Memo

0.00

(10)

SAD

12-01-0509

(10)

12-1-9 (10)

(10)

SAD

12-1-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76757

November-21-11 10:29:14 AM

76757

Page 2

Item ID: D2654-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 21/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 02/01/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00				10	SAD	12-01-09	
Quality Control									

140	Identify as per dwg & Stock Location: <u>L6</u>	0.00							
140									
Packaging	Memo	0.00				(10)	EF/SAD	12-1-9	
Packaging									

150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

ME
12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 21/11 10:39 AM

Work Order ID: 76757

Parent Item: D2654-1

Parent Item Name: Web

76757

D2654-1

Start Date: 21/11/2011

Required Date: 02/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	261.0000	1	10			

D2600-5-108

Extrusion 'I Beam' thin

**

Location

LG

Loc Qty

261

Loc Code

47814

20

73909

241

D 2600.5-080

B 73861

(10)

CF

12-01-06

~~10~~ ~~12-01-06~~

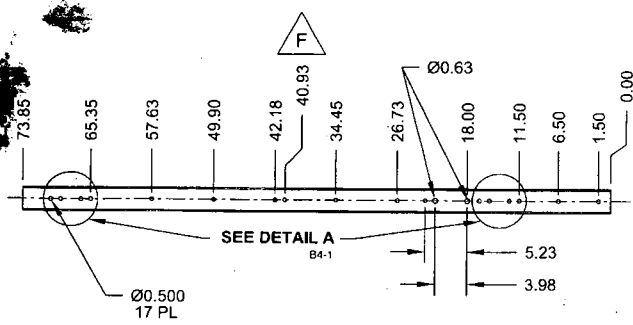
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

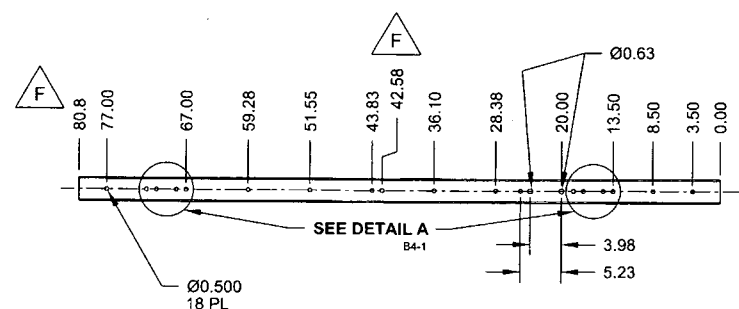
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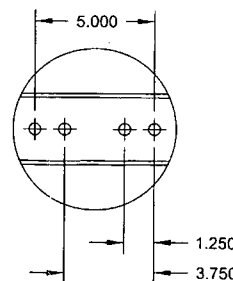
NOTE: Date & initial all entries



D2654-1 WEB



D2654-3 WEB



DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO REVISION
WITHOUT NOTICE
WORK ORDER
NO. 76757 M.C.J.
11/11/21

RELEASED
2011-09-12

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHV HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	97	DRAWING NO.	REV. F
MFG. APPR.	8	D2654	SHEET 1 OF 2
APPROVED	142	TITLE	SCALE
DE APPR.	14	WEB	ENTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE BASIS OF CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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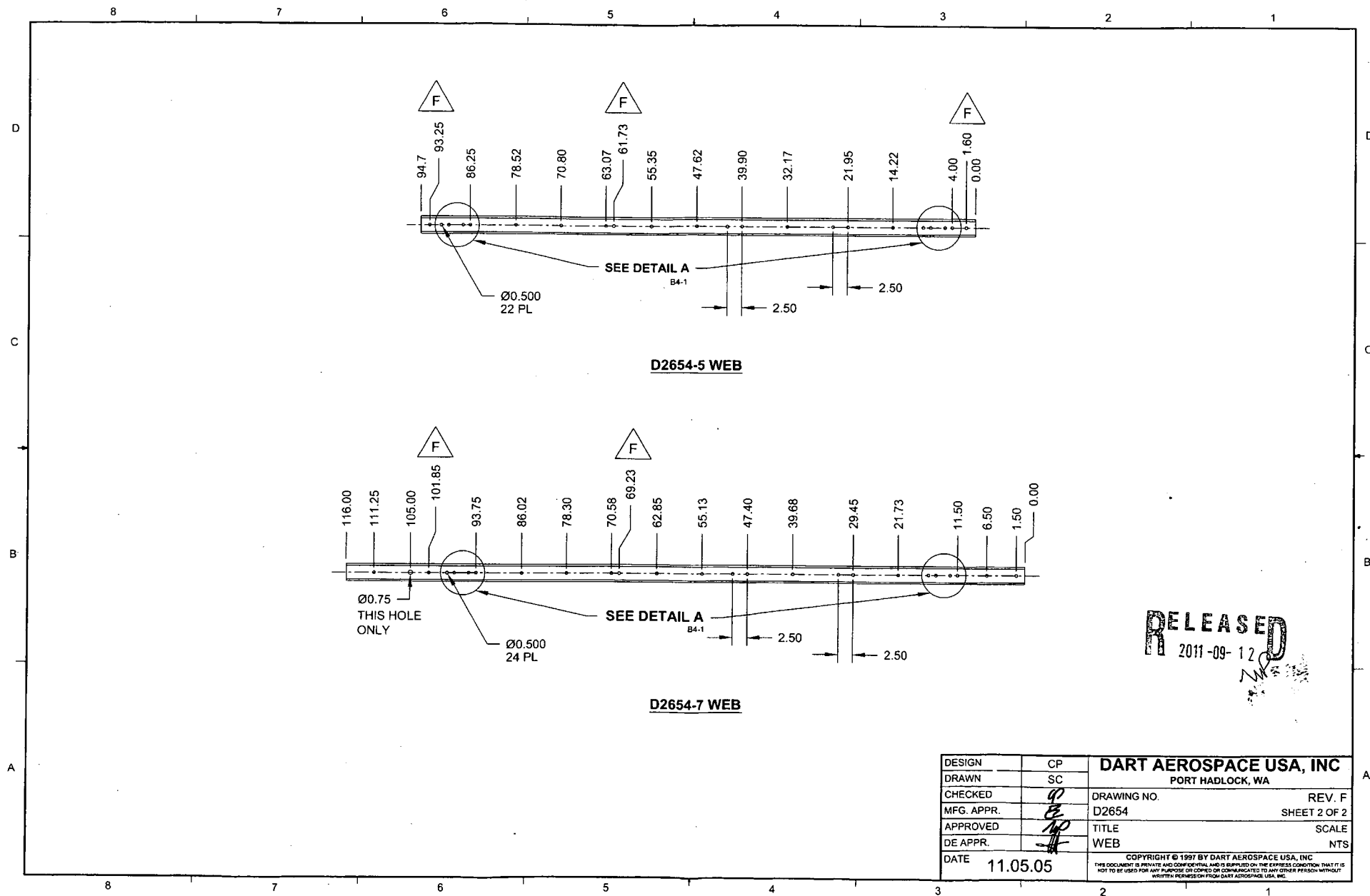
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RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. F
MFG. APPR.	E	D2654	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	11	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: X QA: N/C Closed: _____ Date: _____

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